

**ABSTRACT OF THE DISCLOSURE**

Where can bodies of sheet metal are welded between the welding rollers of a welding machine, the welding current is not applied to the welding rollers until the body is between 5 the welding electrode rollers. In this way, the quality of the weld at the initial weld point is improved, and where intermediate wire electrodes are used, wire breaks are reliably prevented.

009316378 8270704